

Date: Tuesday, 28/04/2009 7:42:29 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUAL MIRROR ASSEMBLY
 Job Number : 47483
 Estimate Number : 12278
 P.O. Number :
 This Issue : 28/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D206558043
 Drawing Number : IIN206-558
 Project Number : N/A
 First Issue : 27/04/2009 Type : SMALL /MED FAB Drawing Revision : C
 Material :
 Previous Run : 42035 Due Date : 05/05/2009 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. 002.09.19 Re-format; Incorporated D2066 KJ
 Est Rev:H 08-05-14 now @ chg006/ add D3778-1 per ECN1171
 DD verified:
 Est Rev:I 08-08-19 now @ chg 007 DD verified by:ec

Additional Product

Job Number:



D2011 Rev.G ✓
 D2829 Rev.B

Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

ECN08-548

Photocopy bluefile and create labels per PPP D206-558-043 CHG006



2005.25 per 2.0.

2.0

D2011101

6" Mirror



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Mirror 6"

Pick:

Qty Part Number Description Batch
 2 D2011-101 Mirror Ass'y 6"

Batch

347592

FF 09-05-21

3.0

D2052

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bracket

batch: B 39556

FF 09-05-21

4.0

D2054

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing - Delrin

batch: B39433

FF 09-05-21

Date: Tuesday, 28/04/2009 7:42:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL MIRROR ASSEMBLY

Job Number: 47483

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2055

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clamp

batch: B34365

FF 09-05-21 (5)

6.0

D2056

Bell Crank



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bell Crank Assembly

batch: B39434x2 / B45542x3

FF 09-05-21 (5)

7.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M111279

FF 09-05-21 (5)

8.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

batch: M110844

FF 09-05-21 (5)

9.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: M110916

FF 09-05-21 (5)

10.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 2.5053 f(s)/Unit Total : 12.5265 f(s)

304 RD Tube .500 x .049W

304/316 SS Seamless Tube

batch: 111814

FF 09-05-20 (5)

Date: Tuesday, 28/04/2009 7:42:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL MIRROR ASSEMBLY

Job Number: 47483

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Punch 1/2" OD x .036" Wall 304/316 SS Seamless Tube

(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)

Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

4-Bend per Dwg D2066

5-Drill 3/16" (0.188") Dia holes per Dwg D2066 using drill jig DT9034 and template DT8054

6-Polish and Deburr

7- assemble parts as per dwg D2066

FF 09-05-21 (5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/21 (X5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

14.0

D2053

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number Description Batch

1 D2053

Bracket

38531

S 09/05/21 (X5)

15.0

D37781

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

batch:

45576

S 09/05/21 (X5)

Date: Tuesday, 28/04/2009 7:42:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL MIRROR ASSEMBLY

Job Number: 47483

Part Number: D206558043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

16.0	D2067	Connector
------	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Connector

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2067	Connector	
---	-------	-----------	--

39558

SS 09/05/21 (X5)

17.0	D2071	Cable Assembly
------	-------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Cable Assembly

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2071	Cable	
---	-------	-------	--

42510

SS 09/05/21 (X5)

18.0	AN34A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	AN3-4A	Bolt	
---	--------	------	--

M103041

SS 09/05/21 (X5)

19.0	AN5261032R9	Screw
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Screw

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	AN526-1032R9	Screw	
---	--------------	-------	--

or AN526C1032R9

M9210

M12241

SS 09/05/22 (X5)

20.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

6	AN960JD10L	Washer	
---	------------	--------	--

M109632

SS 09/05/21 (X5)

Date: Tuesday, 28/04/2009 7:42:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL MIRROR ASSEMBLY

Job Number: 47483

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS21919DG5

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21919DG5 Clamp → 11325 M108205

or MS21919WDG5

88 09/05/21 (15)

22.0

MS354899

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Grommet

Pick: Packing Kit

Qty Part Number Description Batch

1 MS35489-9 Grommet

M107376

88 09/05/21 (15)

23.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

batch:

M110844

88 09/05/21 (15)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

88 09/05/21 (15)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-558-043

Location:

PPP Rev:

11

9/5/25

SP

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



mf 09-05-25

8 7 6 5 4 3 2 1

D

D

C

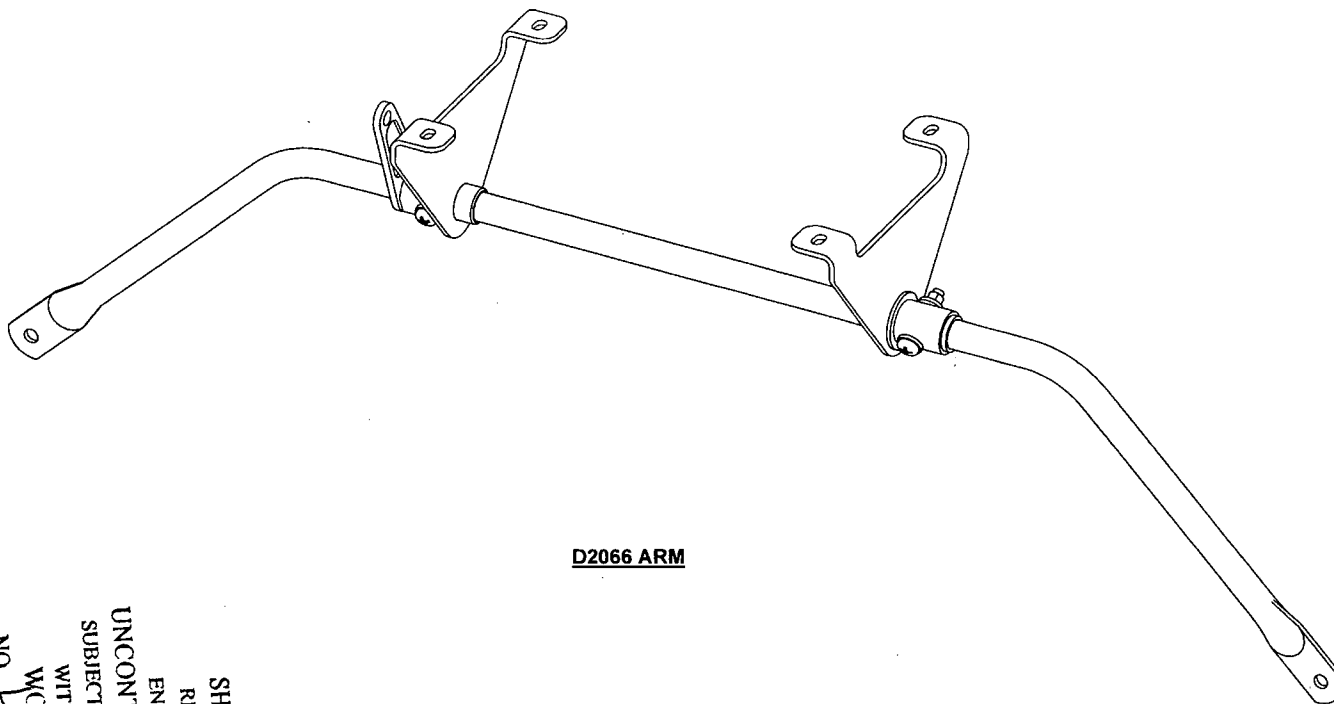
C

B

B

A

A



D2066 ARM

RELEASED
08.07.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1498

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2066 REV. C SHEET 1 OF 2 TITLE ARM SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	FW		
CHECKED	h		
MFG. APPR.	h		
APPROVED	h		
DE APPR.	h		
DATE	08.06.12		

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

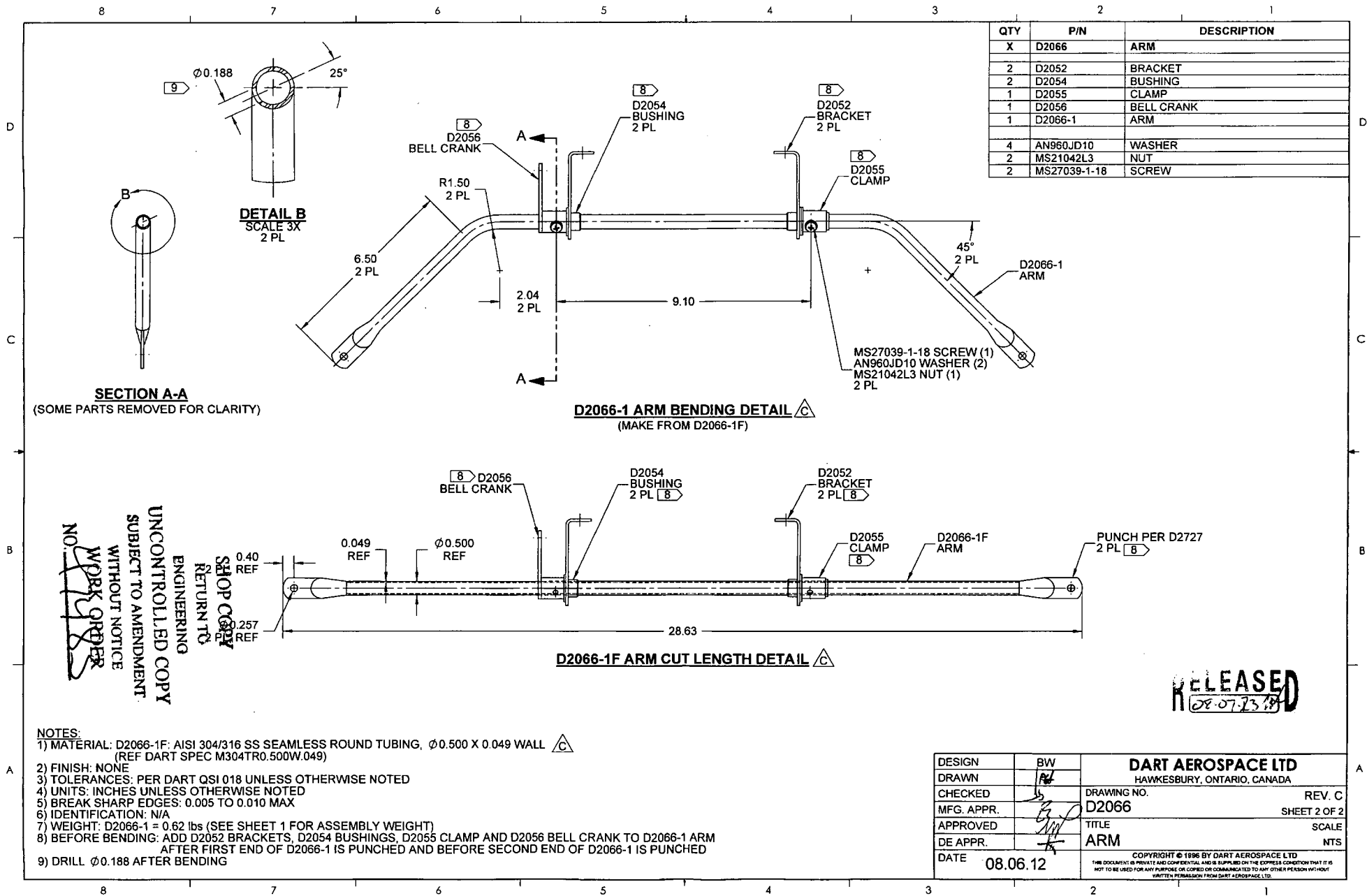
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

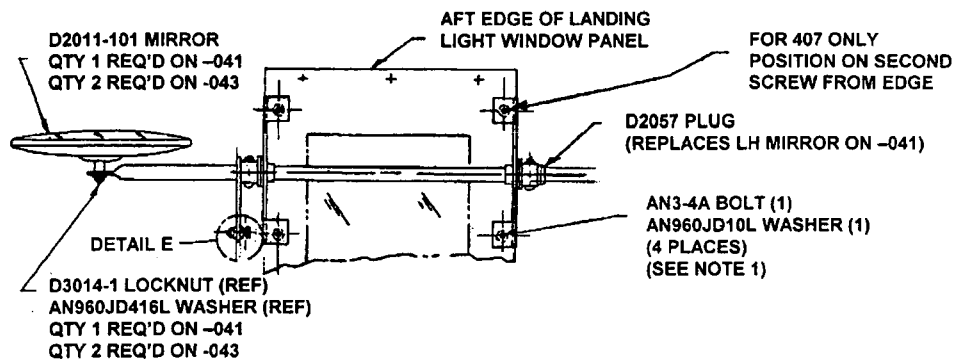


Figure 3: - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

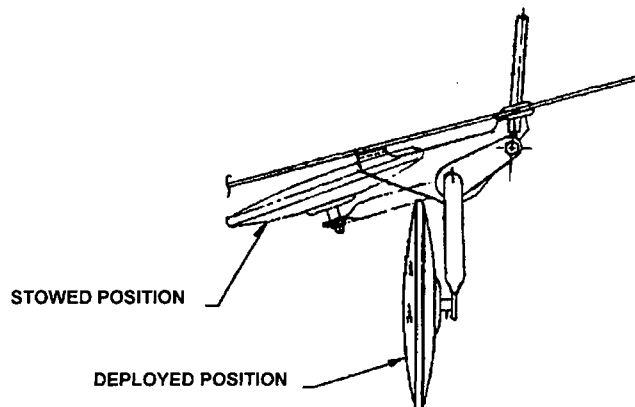


Figure 4: - Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

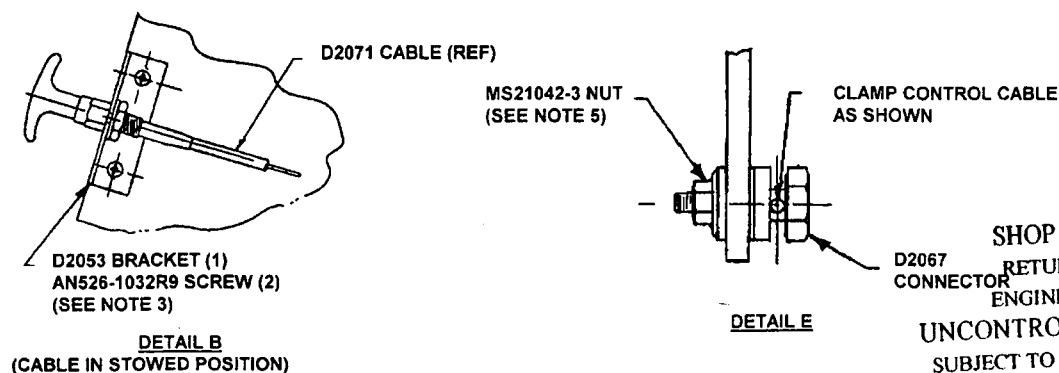


Figure 5: - Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 471483

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

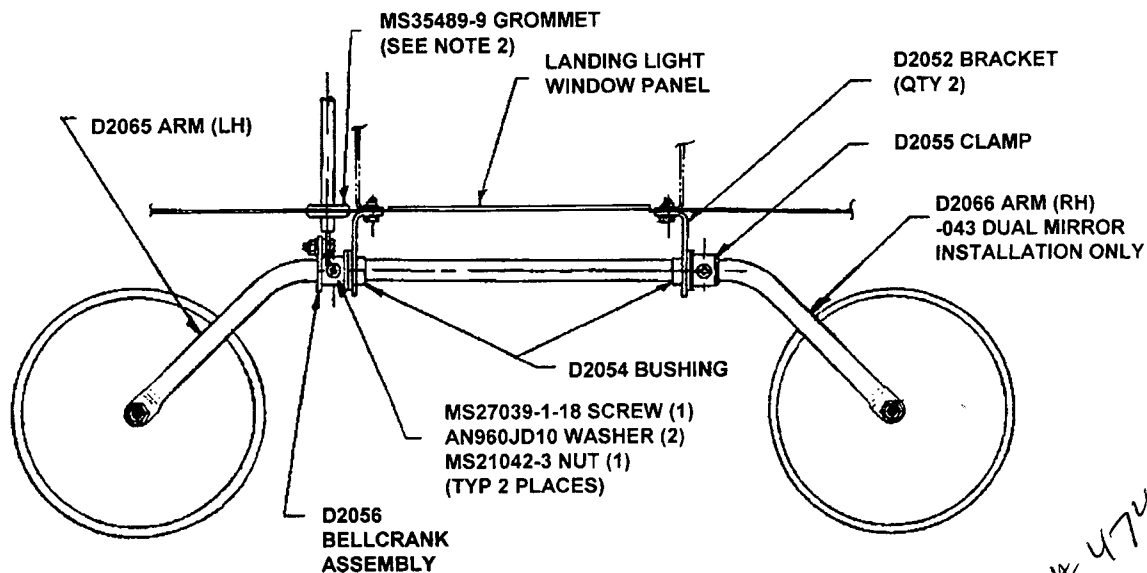


Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)

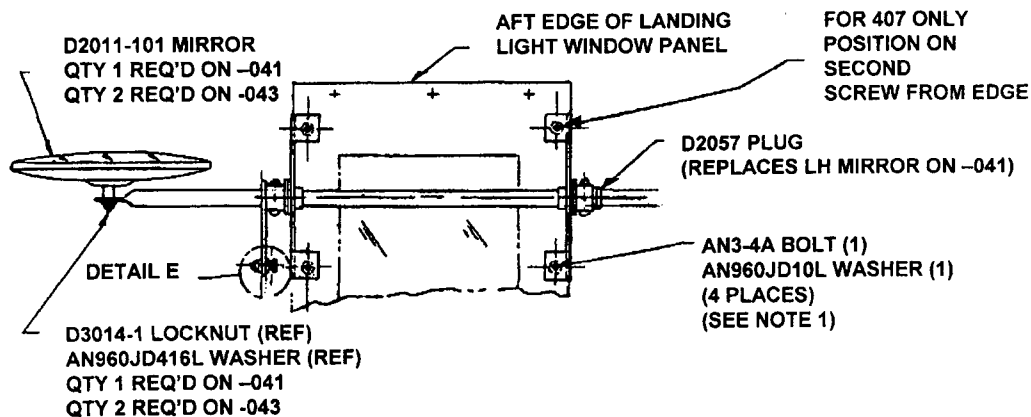


Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

• COPYRIGHT © 2001 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00